

File: Thursday, 21/05/2009 11:21:57 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RIB
Job Number : 48101	
Estimate Number : 13673	
P.O. Number :	Part Number : D22211
This Issue : 21/05/2009 S.O. No. :	Drawing Number : D2221 REV H (PG.5)
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : H
Previous Run : 47952	Material :
Written By :	Due Date : 27/05/2009 Qty: 8 Um: Each
Checked & Approved By : <u>JLD 09.05.21</u>	
Comment : Est Rev:A New Issue 08-12-02 DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
<p><i>Scrap End bar 3.5 x 8 = 28" / 12 = 2.33sf</i></p> <p>Comment: Qty.: 8.4000 f(s)/Unit Total: 67.2000 f(s) 304 SQ Tube .75x.75x.065W batch: <u>M111885</u></p>		
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
<p>Comment: LARGE FABRICATION RESOURCE 1</p> <p>1- Cut as per dwg D2221 2- Deburr and remove identification markings on tube</p>		
3.0	QC5	INSPECT WORK TO CURRENT STEP
<p>Comment: INSPECT WORK TO CURRENT STEP</p>		
4.0	PACKAGING 1	PACKAGING RESOURCE #1
<p>Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>WA</u></p>		
5.0	QC21	FINAL INSPECTION/W/O RELEASE
<p>Comment: FINAL INSPECTION/W/O RELEASE</p>		
<p>Job Completion</p>		

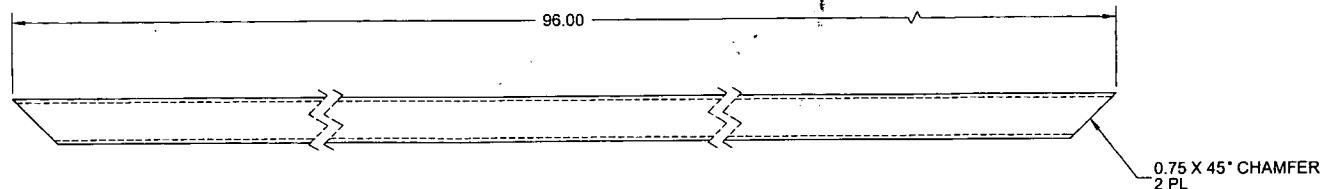
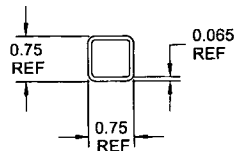
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

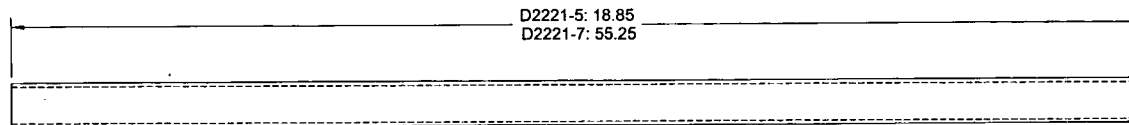
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

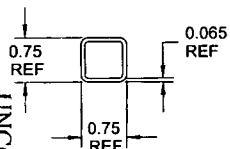
NOTE: Date & initial all entries



D2221-1 RIB



D2221-5/-7 RIB



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 48101

RELEASED
08/11/18

- NOTES:**
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
 REF. DART SPEC. M304TS0.750W0.065
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	MD	D2221	SHEET 5 OF 5
APPROVED	ML	TITLE	SCALE
DE APPR.	SH	BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries